



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE105-31702W24-PO
Job Sheet 186026



Part No: RBE105-31702W24-PO

Job Qty: 1 ea

Part Name: Tail Rotor Fork Shaft Check



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/8/18

Job Tracking No:

Due Date: 12/18/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBE105-31702W24 Rev.1 IPP Rev. A 18.10.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs		12/6/18	0.00	0.00	Purchasing		DEC 12 2018
110	Packaging	1 pcs		12/6/18	0.00	0.00	Packaging2		DEC 12 2018
120	QC	1 pcs		12/6/18	0.00	0.00	QC6		DEC 12 2018
130	Packaging	1 pcs		12/6/18	0.00	0.00	Packaging3		DEC 12 2018
140	QC21-FG	1 Ea		12/6/18	0.00	0.00	QC21		DEC 12 2018

Part Op 100 - Issue P/O: 041662 MANUFACTURE RBE105-31702W24 AS PER DWG Supplier: METEC Certificate of Descriptions: conformity is required

NOV 08. 2018 x 1

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE105-31702W24P	Tail Rotor Fork Shaft Check	1 Ea (1 ea)	100-Purchasing	5137405

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBE105-31702W24P	1	0	0

Part Specifications

Specifications could not be found.

Plex 11/8/18 11:08 AM dart.Lussier.Patrick



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S137410



Part: RBE105-31702W24

Job No: 186026

Serial No/Batch: S137410

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 12/12/18

1

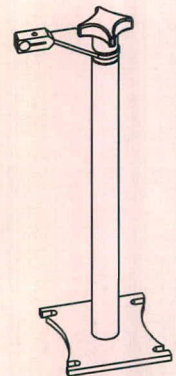
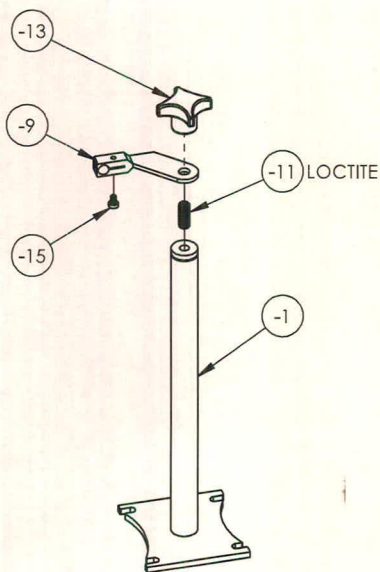
1000 1000

1000 1000

1000 1000

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
1		RELEASED FOR PRODUCTION.	8/1/2016	RJC
				JAG



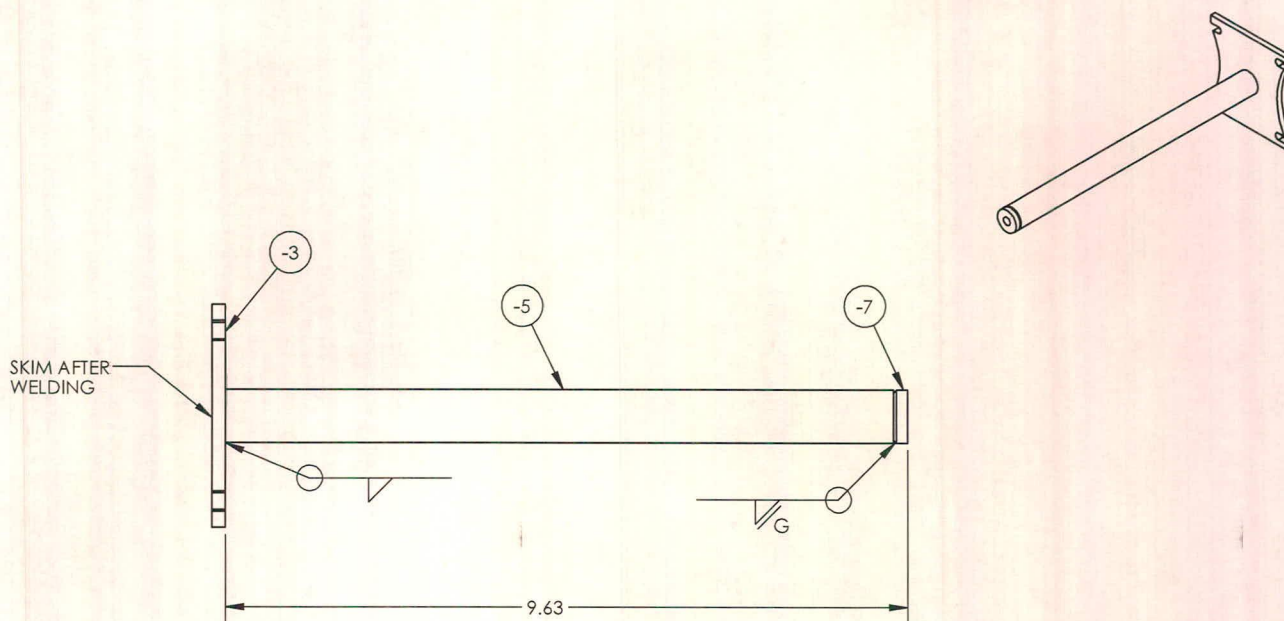
NOTE:
REF. EUROCOPTER T/N 105-31702W24.

DART AEROSPACE	
TITLE MEASURING DEVICE	
DWG NO. RBE105-31702W24	REV 1
MAT'L _____ TREAT _____ FINISH _____ SPEC _____	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL EC145	
SCALE 1:4	DATE 7/15/2016
SHEET 1 OF 6	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	WELDMENT			2
	1		-3		BASE PLATE	A36/1018/1020 HR		3
	1		-5		TUBE	DOM		4
	1		-7		CAP	A36/1018/1020 HR		5
			-9	1	ARM	A36/1018/1020 HR		6
		8/O	-11	1	SET SCREW	STEEL	M8 X 1.25 X 20mm (MCMASTER-CARR #93245A145)	1
		8/O	-13	1	FOUR ARM KNOB	PHENOLIC	M8 X 1.25, 40mm (MCMASTER-CARR #6390K23)	1
		3/O	-15	1	SOCKET HARD CAP SCREW	STEEL	M4 X .7 X 6mm (MCMASTER-CARR #90327A111)	1
	ASSY -1							

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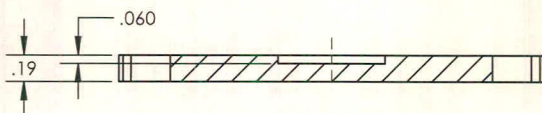
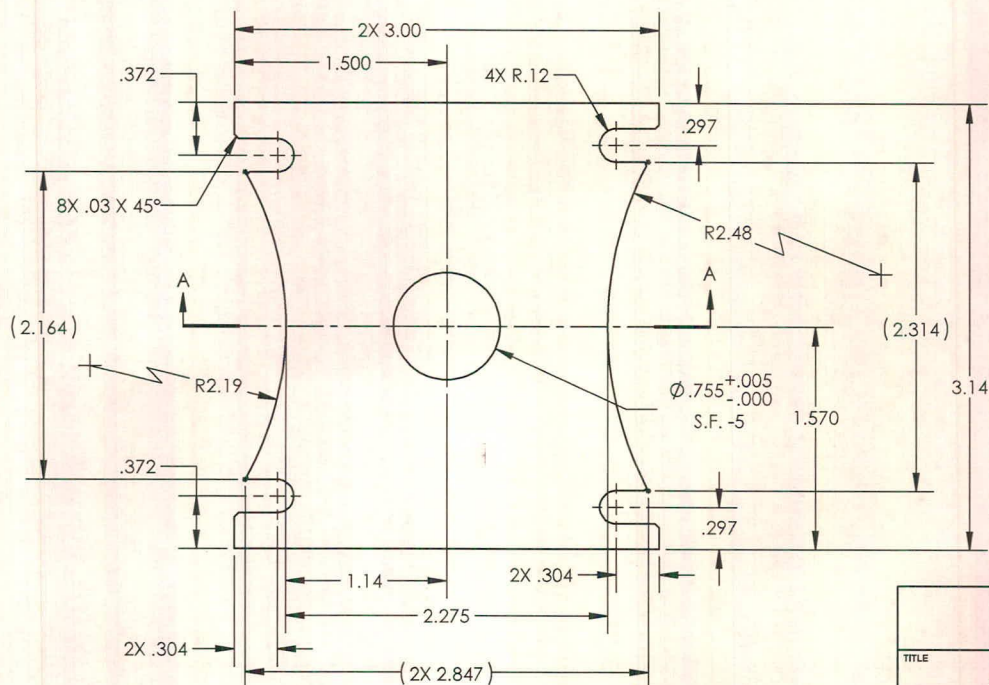


(-1)
WELDMENT

DART AEROSPACE	
TITLE MEASURING DEVICE	
DWG NO. RBE105-31702W24-1	REV 1
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EC145
SCALE 1:2	DATE 7/15/2016 SHEET 2 OF 6

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SECTION A-A

(-3)

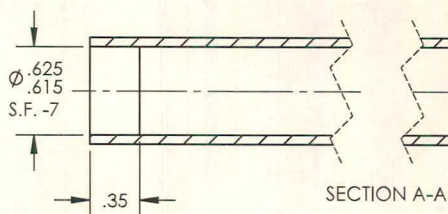
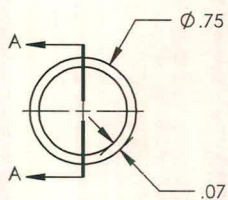
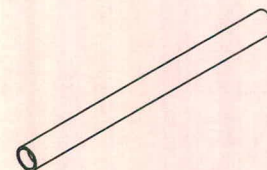
BASE PLATE



TITLE		MEASURING DEVICE	
DWG NO.	RBE105-31702W24-3	REV	1
MAT'L	A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED	
HEAT	TREAT	DIMENSIONS ARE IN INCHES	
FINISH	SEE -1	.XXX	± .010 FRACTIONS ± 1/8
SPEC		.XX	± .03 ANGLES ± 1°
		.X	± .1 SURFACES = 125
DRAWN BY:	CLOUGH	1. BREAK ALL SHARP EDGES	
CHECKED:	DUERFELDT	2. DIMENSIONAL LIMITS APPLY	
OPPS APPR:	ANDERSON	AFTER PLATING	
QA APPR:	LINDSAY	3. INTERPRET DIM AND TOL PER	
APPROVED:	GILBERT	ASME Y14.5M-2009	
SCALE		USED ON MODEL	
1:1		EC145	
DATE		7/15/2016	
SHEET 3 OF 6			

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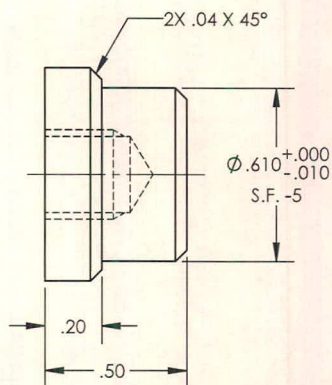
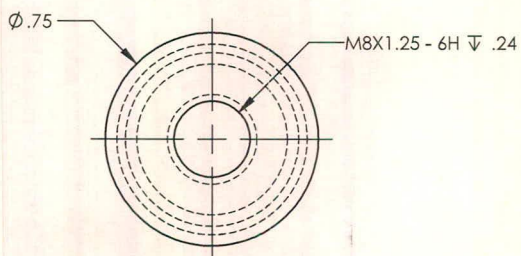
(-5)

TUBE

DART AEROSPACE	
TITLE MEASURING DEVICE	
DWG NO. RBE105-31702W24-5	REV 1
MAT'L DOM	UNLESS OTHERWISE SPECIFIED
HEAT	DIMENSIONS ARE IN INCHES
TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE -1	.XX ± .01 ANGLES ± .5°
SPEC	.X ± .1 SURFACES = 125 ✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 X 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.6M-2009
	USED ON MODEL
	EC145
SCALE 1:1	DATE 7/15/2016
	SHEET 4 OF 6

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REV	ECR	DESCRIPTION	DATE INITIAL APPROVED

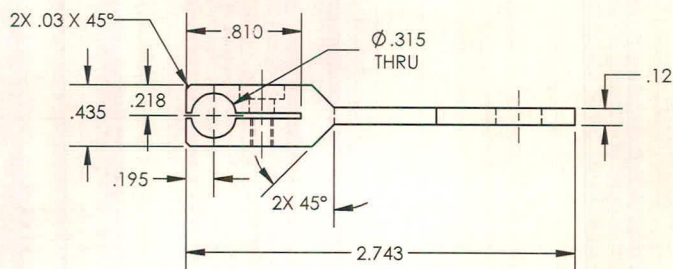
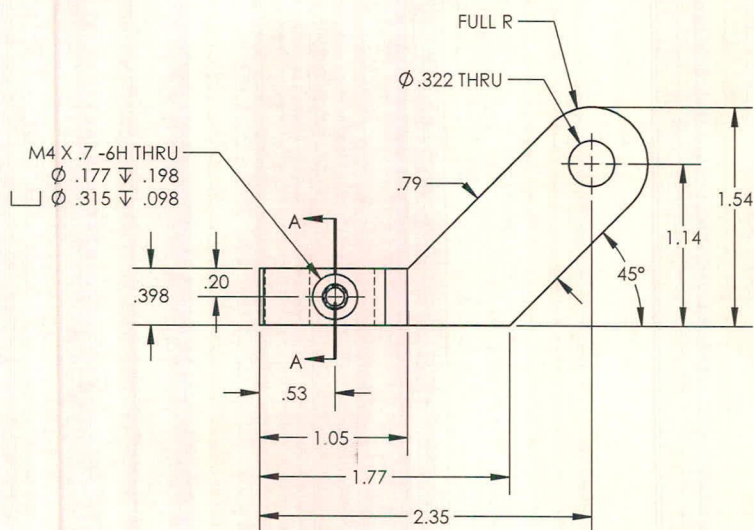


⑦
CAP

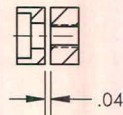
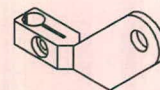
DART AEROSPACE	
TITLE MEASURING DEVICE	
DWG NO. RBE105-31702W24-7	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
REAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125 ✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 X 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
QA APPR: LINDSAY	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: GILBERT	USED ON MODEL
	EC145
SCALE 2:1	DATE 7/15/2016
	SHEET 5 OF 6

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REV		ECR	REVISIONS		DATE	INITIAL	APPROVED
			DESCRIPTION				



ARM



SECTION A-A

DART AEROSPACE	
TITLE MEASURING DEVICE	
DWG NO. RBE105-31702W24-9	REV 1
MAT'L A36/1018/1020 HR HEAT TREAT FINISH ZINC PLATE SPEC ASTM B633 TYPE I SC 2	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .008 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: CLOUGH CHECKED: DUERFELDT OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
USED ON MODEL EC145	
SCALE 1:1	DATE 7/15/2016
SHEET 6 OF 6	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041662**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

PO No: PO041662
PO Date: 11/8/18
Due Date: 12/14/18
Purchase Order Revision: (14)
Revision Date:
Ship-To Contact: Phone:

Attention: Walz, Shigi

Via: Ground
Pymt Terms: Net 60

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	186026	RBE105-31702W24P			Tail Rotor Fork Shaft Check REV 1	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$0.01/Ea	\$0.01
Grand Total:													\$0.01

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 11/8/18 11:12 AM dart.Lussier.Patrick

DAS
38
9-89

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 Canada

Shipment No: 24372
Shipment Date: 11-Dec-2018
Ship Via: Pick up at METEC

Customer Code: DART
Phone: (613) 632-9577

Terms: Net 60 Days

----- Quantity -----								
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Job Number</u>
1	1	1	0	0	EA	DART-RBE105-31702W24P Measuring Device (Tail Rotor Fork Shaft Check) Order No: 3161 Order Date: 11/08/18 PO Number: PO041662	1	3161-01
1	1	1	0	0	EA	DART-RBE105-31702W24P Measuring Device (Tail Rotor Fork Shaft Check) Order No: 3282 Order Date: 12/07/18 PO Number: PO041411	1	3282-01

DAS
38
9-89

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Packing Clerk's Signature
 Metec Metal Technology Inc

Received In Good Order By

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. <u>RBE105-31702W24P Rev. 1</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
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Date : _____	Sequence #: _____	QTY Affected : _____	MRB (QSI042) December 7, 2018
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Description Work Order Deviation	Disposition	
RBE105-31702W24-5 and -7 must be manufactured as one piece from 303/304 Stainless Steel rod. RBE105-31702W24-3 must be manufactured from 303/304 Stainless Steel plate. Zinc Plate is no longer required	This deviation is acceptable. No change to fit form or function of the tool.	Completed By <i>MLee</i> Lead hand / Supervisor QC / QA Coordinator

Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☒ X Process Improvement ☐ Human Factors ☐	FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
Other/Details: _____	



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev#	P.O. Number
1	DART-RBE105-31702W24P	MEASURING DEVICE	1	41662
1	DART-RBE105-31702W24P	MEASURING DEVICE	1	41411
Material supplied by METEC				

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We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

George Theoret

Vankleek Hill, December 11, 2018

